

Work Order ID 144879

144879

Page 1

April 26, 2016 1:39:34 PM

Item ID: D4784-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Assembly, Heavy Duty Lid, LH/RH
 Start Date: 6/3/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Sht Date: 20160426 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4784	D

100 Pick Kit 0.00

100

Packaging Memo 0.00

Packaging

DAS
6
9-89

MAY 30 2016

110 Assemble as per dwg 0.00

110

HandFinish Memo 0.56

Hand Finishing

Transfer drill from D4687-210 to label plate as per dwg. Install as per dwg.

①

DAS
43
9-89

MAY 30 2016

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.02

Quality Control

①

DAS
38
9-89

JUN 02 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144879***144879***

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N900040100Setup Start ***NS1***

Revision ID:

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Start Date: 6/3/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

JUN 03 2016

32

MCS

JUN 03 2016

MCS

JUN 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

April 26, 2016 1:39:38 PM

Page 1
19

Work Order ID: 144879

144879

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.18 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.17 as per dwg rev.A DD VERF:JLM IPP REV:C
13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:D 13.06.21
DWG REV.B DD VERF:JFS IPP REV:E 13.12.02 DWG
REV.C DD VERF:JLM IPP REV:F 15.01.19 DWG REV.pd1
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
97447A010 *97447A010* Blind Rivet		Purchased	No				Each	180.0000		4			DAS 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST589			180						
				m131311			180						
D2530 *D2530* Handle Weldment		Manufactured	No				Each	8.0000		1			DAS 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST379			8						
				132392			8						
D2535 *D2535* Spring		Manufactured	No				Each	61.0000		2			DAS 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST008			36						
				139657			36						
				ST012a			25						
				143808			25						

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Work Order ID: 144879

144879

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

Each

69.0000

2

D2537

Bushing

Location

Loc Qty

Loc Code

ST008

69

141054

14

141583

55

Each

0.0000

1

D3914-041

Manufactured No

D3914-041

Long Basket Lid Assembly (350)

D3917-3

Manufactured No

Each

77.0000

6

D3917-3

Washer

Location

Loc Qty

Loc Code

ST058

77

141536

77

Each

33.0000

2

D3953-3

Manufactured No

D3953-3

Gas Spring Stud, Lid

Location

Loc Qty

Loc Code

ST062

33

141606

33

Each

34.0000

2

D3953-7

Manufactured No

D3953-7

Spring Spacer

Location

Loc Qty

Loc Code

ST062

34

138972

34

DAS
6
9-89

MAY 30 2016

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Work Order ID: 144879

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Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

Each 31.0000

2

D3953-9

147022 sf

Gas Spring Washer

Location

Loc Qty

Loc Code

ST062

31

141591

31

Each

39.0000

2

D3953-17 Manufactured No

D3953-17

Gas Spring Spacer

Location

Loc Qty

Loc Code

ST062

39

141477

21

142705

18

Each

30.0000

1

D3953-19 Manufactured No

D3953-19

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST062

30

138913

30

Each

22.0000

1

D3953-21 Manufactured No

D3953-21

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST063

22

139553

4

141546

18

DAS

6

9-89

DAS

6

9-89

DAS

6

9-89

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Work Order ID: 144879

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Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

Each 15.0000 1

D3969-3

Spring (Basket Lid)

DAS

6

9-89

MAY 30 2016

Location

Loc Qty

Loc Code

ST365

15

140555

5

141701

10

Each

0.0000

1

B144878(1x) 141405/30

D4785-041

Manufactured No

D4785-041

Long Basket Base Assembly, LH/RH

D4786-210

Manufactured No

Each 2.0000

1

145258

DAS

6

9-89

D4786-210

Placard, Max Load

Location

Loc Qty

Loc Code

ST126

2

128577

2

Each

143.0000

4

AN3-14A

Purchased No

AN3-14A

Bolt

Location

Loc Qty

Loc Code

over003

130

m133992

50

m134360

30

m134634

50

ST349

13

m134167

13

DAS

6

9-89

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Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-16A Purchased No

Each 82.0000 2

AN3-16A

DAS
6
9-89

Bolt

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

37

M133790

37

2

AN310C4

Purchased No

Each 77.0000

AN310C4

DAS
6
9-89

Nut

Location

Loc Qty

Loc Code

OVER007

30

M134370

30

ST331

47

M133990

47

2

AN310-4

Purchased No

Each 100.0000

AN310-4

Nut

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

50

M134180

50

ST331

25

M133990

25

3

DAS
6
9-89
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Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

Each 81.0000 3

AN4-12

Bolt

DAS

6

9-89

Location

Loc Qty

Loc Code

ST344

81

m133988

41

m134370

40

AN5-17A Purchased No

Each 133.0000 4

AN5-17A

Bolt

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

33

117872

33

over003

75

m134606

75

ST337

25

m134055

25

MS21042L3 Purchased No

Each 2,081.000 6

MS21042L3

Nut

DAS

6

9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

761

m133790

3

m134360

758

ST303

1220

m134039

12

m134360

608

m134634

600

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Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5	Purchased	No	Each	451.0000	4	DAS
MS21042L5					**	6
Nut						9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	115	
m127813	115	
OVER007	100	
m134509	100	
ST303	236	
m134055	11	
m134567	225	

MS24665-151	Purchased	No	Each	161.0000	3	DAS
MS24665-151					**	6
Cotter Pin						9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	64	
m128401	64	
ST289	97	
m134294	97	

MS24665-300	Purchased	No	Each	39.0000	2	DAS
MS24665-300					**	6
COTTER PIN						9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	30	
118234	30	
ST288	9	
M128812	9	

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Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

Each

1,715.000

8

NAS1149F0332P

DAS

Washer

6

9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

1403

m134257

1403

NAS1149C0432R

Purchased

No

Each

1,165.000

2

NAS1149C0432R

DAS

WASHER

6

9-89

Location

Loc Qty

Loc Code

GA

444

m125807

428

m133790

16

ST266

721

m134073

721

NAS1149F0432P

Purchased

No

Each

1,466.000

6

NAS1149F0432P

WASHER

Location

Loc Qty

Loc Code

ST260a

1000

M134502

1000

ST262

345

M133990

345

st268

121

M132677

121

DAS

6

9-89

April 26, 2016 1:39:38 PM

Shop Packet Print

Page 8

Picklist Print

April 26, 2016 1:39:38 PM

Page 9

Work Order ID: 144879

144879

Parent Item: D4784-011

D4784-011

Parent Item Name: Basket Assembly, Heavy Duty Lid, LH/RH

Start Date: 6/3/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

Each

106.0000

4

NAS1149F0563P

DAS

6

Washer

9-89

Location

Loc Qty

Loc Code

ST261

106

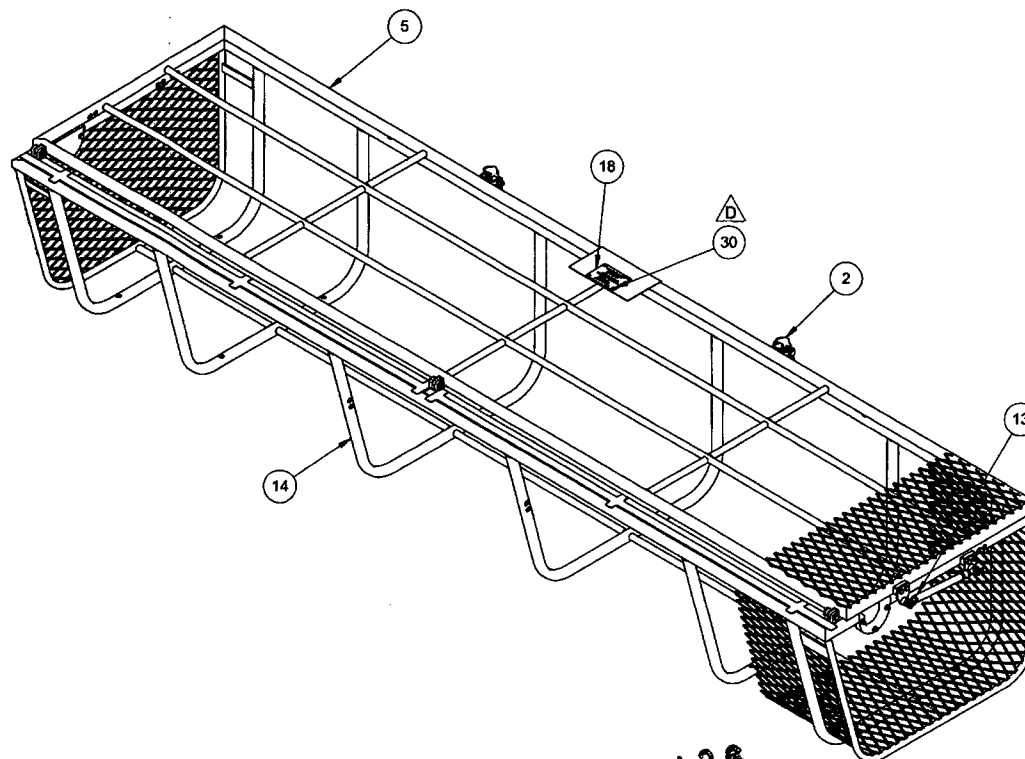
m133515

106

MAY 30 2016

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4784-011	BASKET ASSY, HEAVY DUTY LID, LH/RH
2	1	D2530	HANDLE WELDMENT
3	2	D2535	SPRING
4	2	D2537	BUSHING
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	1	D4785-041	LONG BASKET BASE ASSY, LH/RH
18	1	D4786-210	PLACARD, MAX LOAD
16	4	AN3-14A	BOLT
17	2	AN3-16A	BOLT
18	2	AN310C4	NUT, CASTELLATED
19	3	AN310-4	NUT, CASTELLATED
20	3	AN4-12	BOLT
21	4	AN5-17A	BOLT
22	6	MS21042L3	NUT, SELF-LOCKING
23	4	MS21042L5	NUT, SELF-LOCKING
24	3	MS24665-151	COTTER PIN
25	2	MS24665-300	COTTER PIN
26	8	NAS1149F0332P	WASHER
27	2	NAS1149C0432R	WASHER
28	6	NAS1149F0432P	WASHER
29	4	NAS1149F0563P	WASHER
30	4	97447A010	BLIND RIVET, PAN HEAD

△ D



D4784-011 BASKET ASSEMBLY HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

20160428

SH 144879

RELEASED

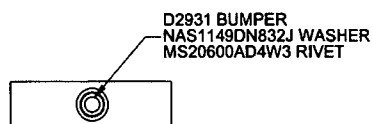
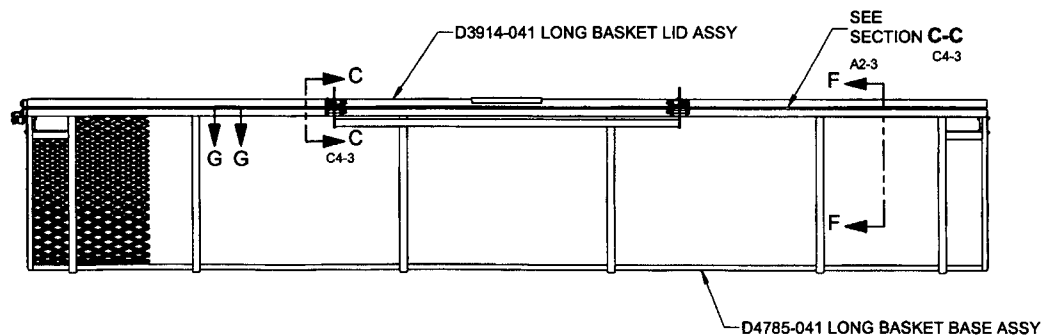
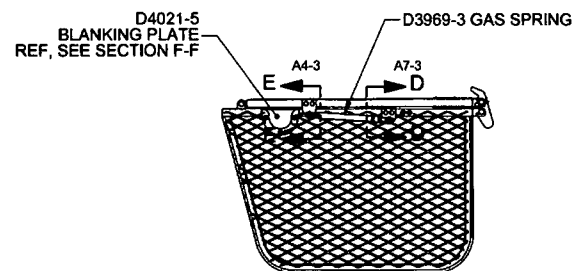
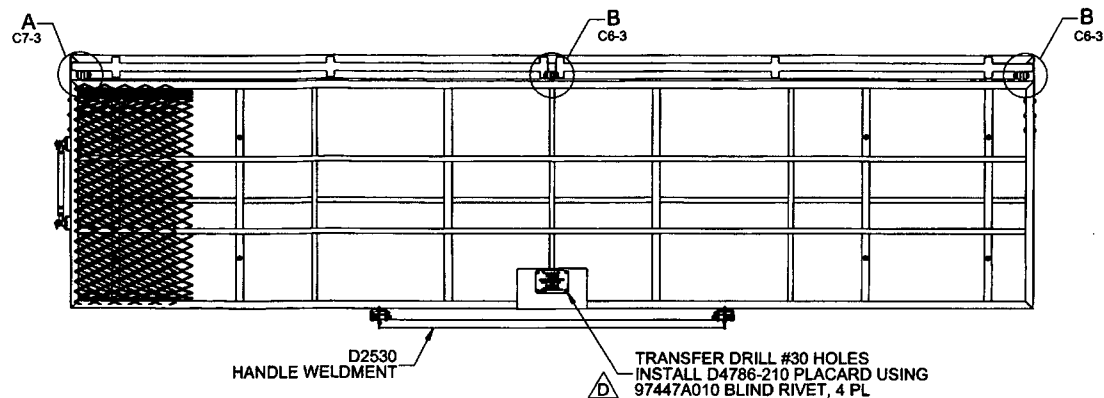
2015 MAR 16
ECN 15-530

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 80.10 lbs

D	ADDED 97447A010 (ZN B6-1 & C3-2)	RF	15.01.13
C	REVISE D3969-3 QTY (ZN C8-1); REF PAR13-315	RF	13.11.25
B	REVISE D4785-041 SHOWN	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4784	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET ASSEMBLY	NTS
DATE	15.01.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



SECTION G-G
(LID ASSY REMOVED FOR CLARITY)

D4784-011 BASKET ASSEMBLY HEAVY DUTY, LH/RH
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

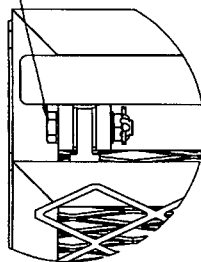
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2015 MAR 16 *up*

APPROVED

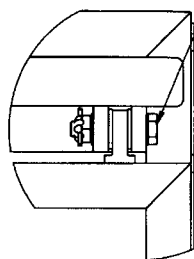
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4784	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET ASSEMBLY	NTS
DATE	15.01.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



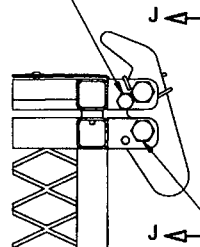
DETAIL A D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



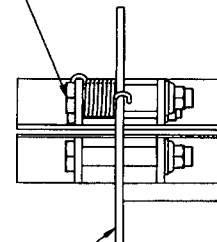
DETAIL B D2-2
D4-2

AN3-16A
MS21042L3 NUT



SECTION C-C B5-2
B3-2

AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

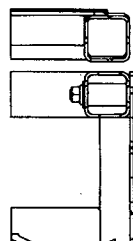
VIEW J-J

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3969-3 GAS SPRING
REF

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

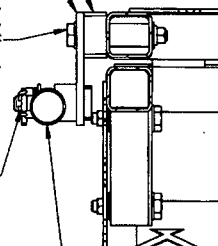


SECTION D-D B7-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

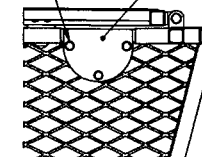
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN



D3969-3 GAS SPRING
REF

SECTION E-E B7-2

AN3-10A BOLT
NAS1149F0332P WASHER
MS21042L3 NUT
3 PL, REF



D4021-5
BLANKING PLATE
REF

SECTION F-F B2-2

RELEASED

2015 MAR 16

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4784	REV. D
MFG. APPR.	DD		SHEET 3 OF 3
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